

Date: Monday, 6/12/2006 2:25:42 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	COVER ASSEMBLY , RH
Job Number	27484	Part Number	D3163042
Estimate Number	10918	Drawing Number	D3163 REV C
P.O. Number	N/A	Project Number	N/A
This Issue	6/12/2006	Drawing Revision	D
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	6/19/2006
Previous Run	25626	Qty:	2
Written By	See comment below		
Checked & Approved By	KJ 06.06.12		
Comment	Est. A 05.10.25 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31631	Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Plate

Pick:

Qty

Part Number

Description

Batch

1

D3163-1/2

Plate

B12381

FF 06.06.12

2

2.0 D31633

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Plate

Pick:

Qty

Part Number

Description

Batch

1

D3163-3

Plate

B12381

A/R

N/A

Sikaflex 241/291

11-2006

Bond D3163-3 to D3163-1 using Sikaflex.
Ensure holes line up

FF 06.06.12

2

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3163-3 to D3163-1 using Sikaflex. Ensure holes line up

FF 06.06.12

2

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect bonding of D3163-1/-3

06.06.14 (2)

N/A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: COVER ASSEMBLY, RH

Job Number: 27484

Part Number: D3163042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

0.m 06/07/18
PL 06/07/21

(2)
P10

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/07/18

(2)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

C'sink D3163-3 as per Dwg D3163.
Touch up c'sink holes with alodine.

FF 06.07.06

8.0 MS20426AD34 S RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD345	Rivet	119099 M4179

FF 06.08.09

9.0 MS21059L08 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
1	MS21059L08	Nut Plate	112706

Assemble nut plate as per Dwg D3163
Identify as D3163-042

FF 06.08.09

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FF 06.08.11

PICK 4 ms20426AD34 Rivet

BATCH: 119099

11021

MS20426AD44 RIVET

ACCEPTABLE DEVIATION

FF 06.08.08

This time only

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-06	8	- 5 rivet required for nut plate ASS'Y. Permanent change, per.	per 06-08-06 per QSS 042	→	2	per 06-08-06 per QSS 042	OL-UE-08

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-05	5.0	S.IKAflex melted in the overheating the 2 plates to shift, misaligning the holes.	QSS 042	Re-work parts to the new Dwg: 03163 Rev.D Starting at step 5. Remove S.IKAflex, and Blockade (AS per QSS 042) as necessary.	FF 06-07-10	✓	QSS 042	OL-UE-08
06-08-11	9.0	Hole size to large. → .128 Human error.	QSS 042 06-08-16	See step, use larger rivet as shown. Acceptable this time only. Verify bit size before using.	FF 06-08-09	✓	QSS 042 06-08-16	OL-UE-08

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 06/08/16

NOTE: Date & initial all entries.

QA: N/C Closed: _____

Date: _____

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Job Number:



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Description :

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink
marker and Stock

Location: ST132

AB 06/08/14

②

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AB 06/08/16

②

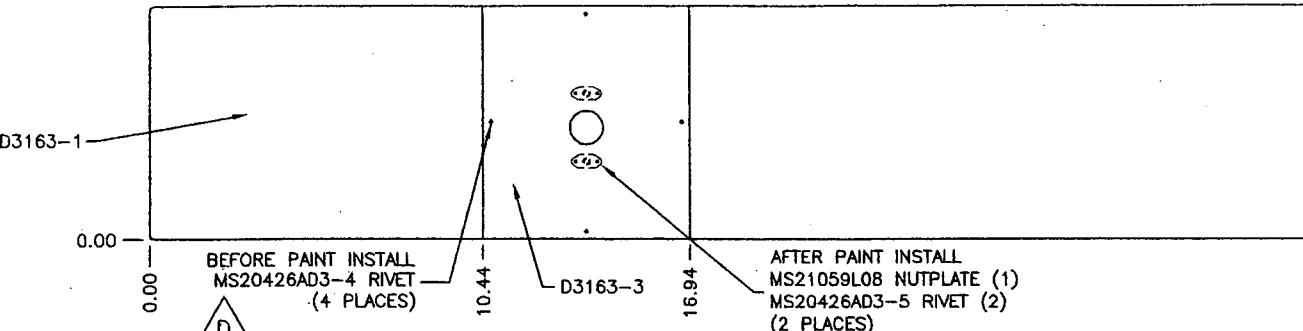
Job Completion



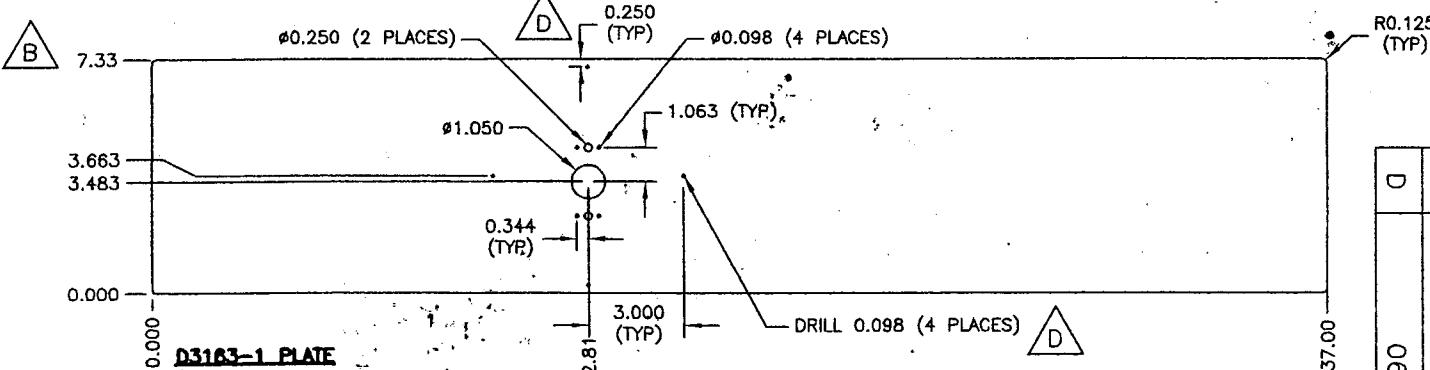
AB 06/08/16

DART**RELEASED**
d.6.29-1

DESIGN RF	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA REV. D
CHECKED <i>Off</i>	APPROVED <i>Off</i>	DRAWING NO. D3163
DATE 06.06.26	TITLE PLATE	SCALE 1:6
		SHEET 1 OF 1



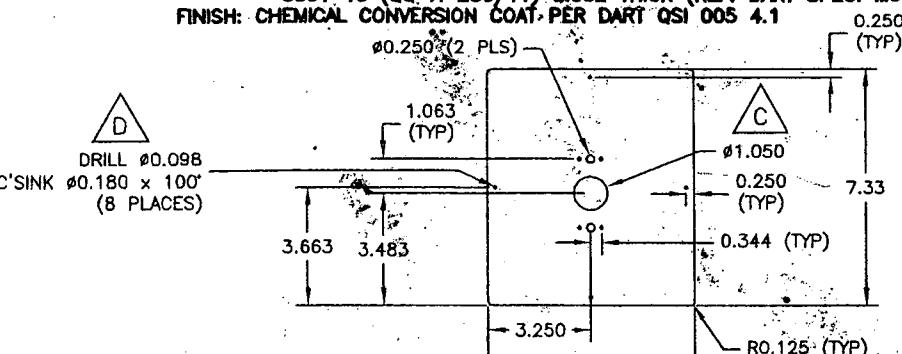
**D3163-041 PLATE SHOWN POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)**



**D3163-1 PLATE
(D3163-2 PLATE OPPOSITE)**

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR
8061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M8061T6S.032)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



D3163-3 PLATE

MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR
8061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M8061T6S.063)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

GENERAL NOTES:

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES.
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER